

Work Order ID 60170

Monday, June 28, 2010 12:59:07 PM



Page 1

Item ID: D3917-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 6/28/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 10-6-28 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3917	a

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA873 & DWG

FOLIO REV: A

DWG REV: 10/06/30

DEBURR

34 ✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10/06/30

34 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

mf 10/06/30



QC

Memo

0.00

Quality Control

34

mf

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

mf 10/06/30 (34)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

mf 10/06/30

mf 10-6-30

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NOTE: Date & initial all entries

Picklist Print

Monday, June 28, 2010 12:59:06 PM

Page 1

Work Order ID: 60170



Parent Item: D3917-1



Parent Item Name: Washer

Start Date: 6/28/2010

Required Date: 7/2/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750		Purchased	No			100	f	70.2100	0.02	0.631579			



Delrin Round Bar 0.75"



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	38.3	
114595	38.3	
MAT050	31.91	
112418	0.12	
112480	31.79	

.521512.010030

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

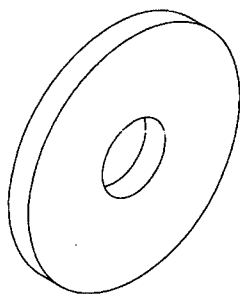
W/O:			WORK ORDER CHANGES					
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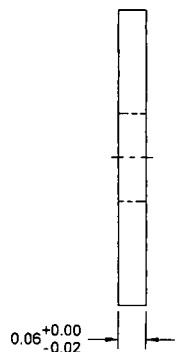
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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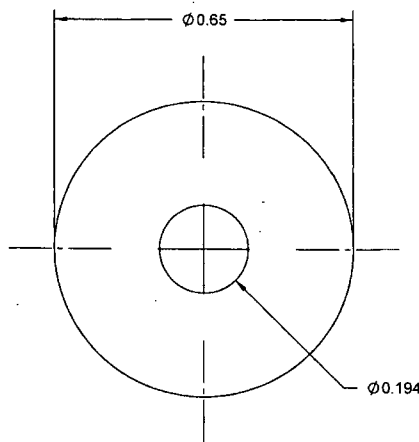
NOTE: Date & initial all entries



ISO VIEW

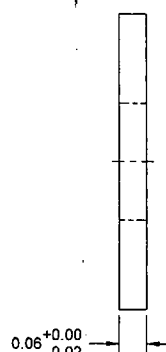


0.06^{+0.00}
-0.02

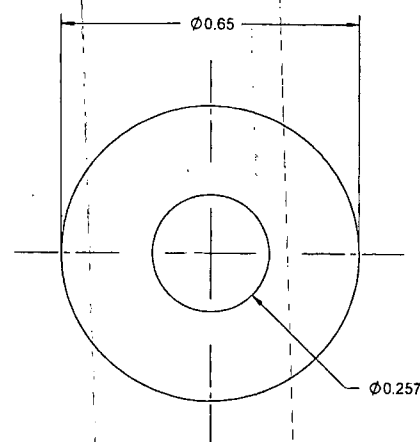


D3917-1 WASHER

60170



0.06^{+0.00}
-0.02



D3917-3 WASHER

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, COLOR BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.	R	D3917	SHEET 1 OF 1
APPROVED	49	TITLE	SCALE
DE APPR.	#	WASHER (350 BASKET)	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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